

# Work Order ID 73838

Friday, September 16, 2011 12:31:20 PM



Page 1

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop



Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☒ Fixturing Inspection last completed  
11/11/13 by FK. ☐ 1-Machine Step No 1 of Folio and visually inspect as  
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually  
inspect as per attached Dimension

B.A. 11/11/15  
FK 11/11/13

10 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

B.A. 11/11/15

10 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FK 11/11/13

B.A. 11/11/15

10 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

**Work Order ID 73838**

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Page 2

Item ID: D2661-1

Accept

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/16/2011 Start Qty: 10.00

Required Date: 10/14/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Handwritten signature**10 X*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*10X M-11/11/16*

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

*8:30**3200F**9:00**10X M-11/11/17**M 118434*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 73838

Friday, September 16, 2011 12:31:20 PM



Page 3

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 11-11-17

170

Identify as per dwg & Stock Location: 435

0.00



Packaging

Memo

0.00

Packaging

11/11/17 SP (10)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/17 SP

11/11/17 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Friday, September 16, 2011 12:31:17 PM

Page 1

Work Order ID: 73838

Parent Item: D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206



Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00:11.01 Removed P/O for Powder Coat - in house process EC  
IPP Rev: D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	13.0000	1	10			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

8

72226

8

MAT44

5

72226

5

B 74680 x 4  
B 73780 x 6

F.K. 11/4/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

H:\FORMS\Quality Assurance\approved QANCRWO RevE.



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 73838
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b> D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D		Page 1 of 1

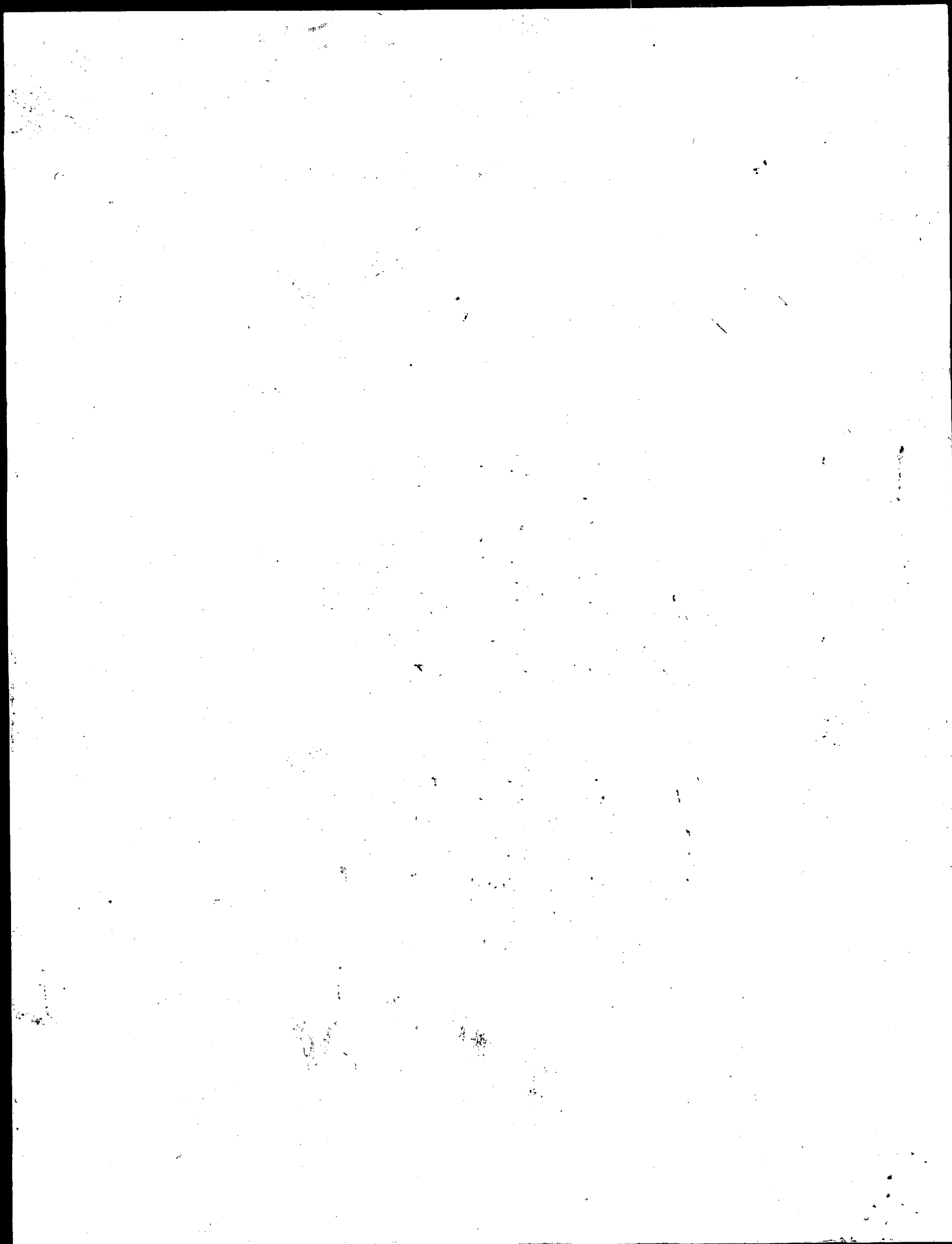
Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.132	.134	.134	.135		
B	0.100	0.140		.122	.122	.123	.122		
C	1.125	1.145		1.131	1.1321	1.1327	1.133		
D	0.615	0.685		.680	.680	.680	.680		
E	0.240	0.260		.245	.253	.253	.253		
F	1.313	1.343		1.316	1.323	1.324	1.325		
G	0.210	0.230		.222	.222	.225	.224		
H	0.100	0.180		.140	.135	.140	.140		
I	2.470	2.510		2.490	2.491	2.490	2.491		
J	1.565	1.585		1.579	1.580	1.580	1.5792		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		.111	.111	.111	.111		
M	0.990	1.010		.999	.998	.998	.999		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	.314		
S	0.315	0.322		.316	.315	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.797	.795	.795		
W	0.540	0.560		.554	.553	.554	.556		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.922	.925	.923	.925		
AA	0.490	0.510		.496	.498	.495	.497		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: EK. / SA
Date: 11/11/13 / 11/11/15

Audited by: [Signature]
Date: 11/11/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 73838
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b> D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D		Page 1 of 1

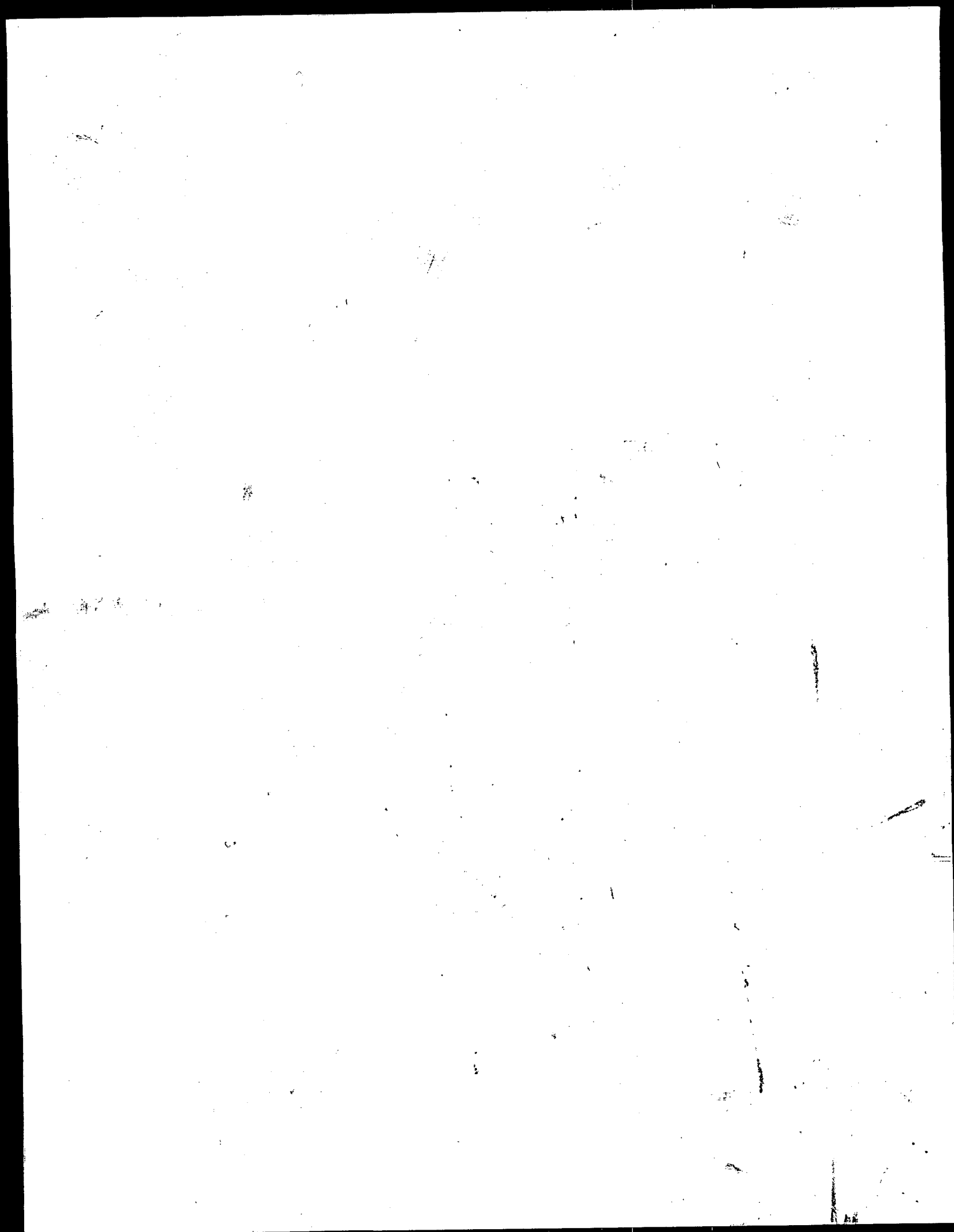
Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.100	0.140		.135	0.130	0.132	.132		
B	0.100	0.140		.122	.122	0.122	.122		
C	1.125	1.145		1.139	1.1307	1.132	1.1335		
D	0.615	0.685		.680	.680	0.680	.680		
E	0.240	0.260		.252	.253	0.253	.250		
F	1.315	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		.222	.222	0.222	.220		
H	0.100	0.180		.140	.140	0.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.577	1.5792	1.5794	1.5768		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.111	0.111	0.111	0.111		
M	0.990	1.010		.998	.998	0.999	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	0.313	.313		
S	0.315	0.322		.316	.316	0.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.794	.799	.798	.797		
W	0.540	0.560		.554	.553	0.558	.556		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	0.257	.257		
Z	0.912	0.932		.926	.919	0.920	.919		
AA	0.490	0.510		.497	0.490	0.490	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	F.K. / H.A.
Date:	11/11/14 / 11/11/15

Audited by:	<i>[Signature]</i>
Date:	11.11.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686, & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 73838
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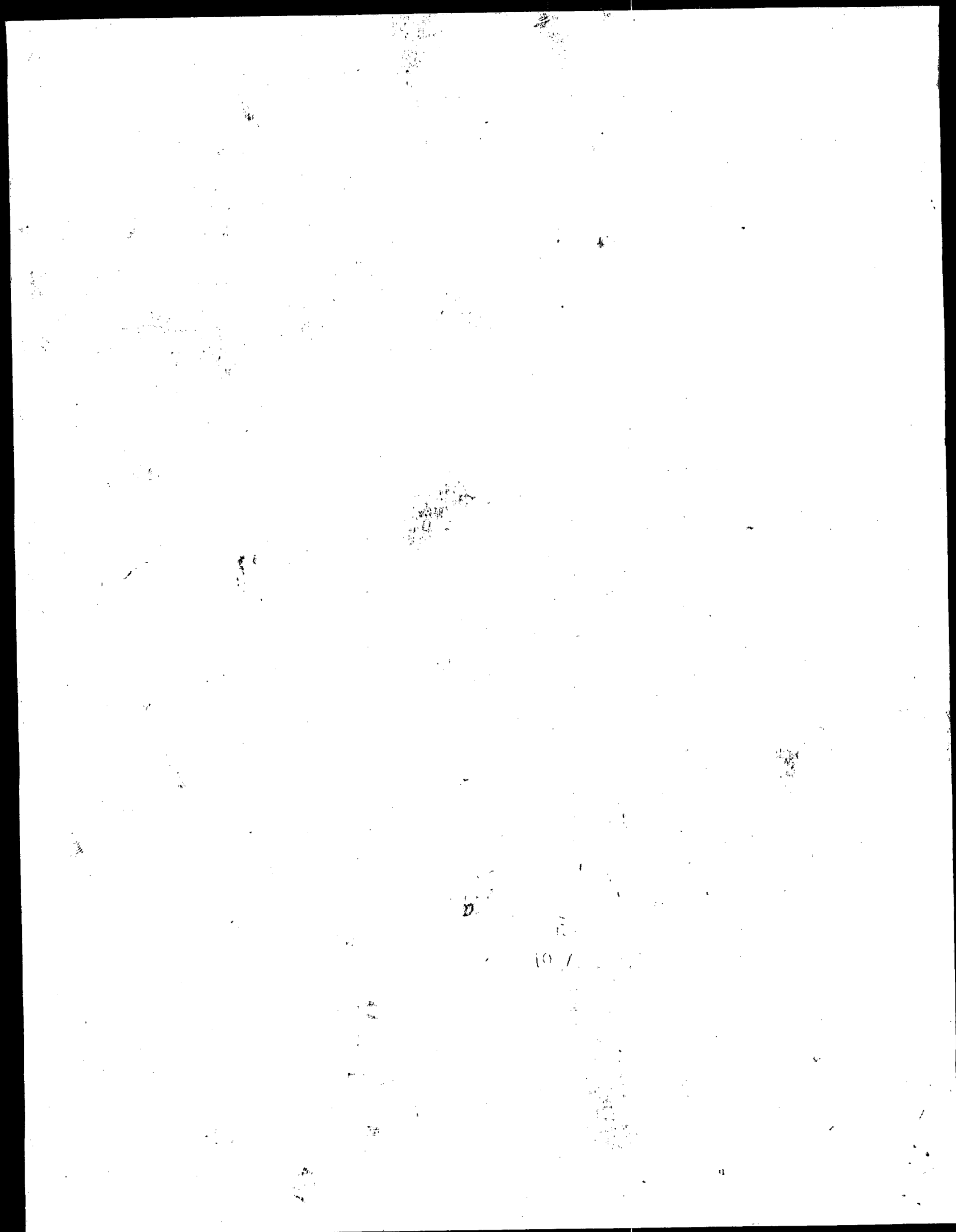
Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	3	4		
A	0.100	0.140		0.130	0.125				
B	0.100	0.140		.122	0.124				
C	1.125	1.145		1.1364	1.140				
D	0.615	0.685		.680	0.680				
E	0.240	0.260		0.251	0.253				
F	1.313	1.343		1.326	1.326				
G	0.210	0.230		.222	0.222				
H	0.100	0.180		0.140	0.140				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.5783	1.5785				
K	0.235	0.240		0.237	0.237				
L	0.100	0.120		0.111	0.111				
M	0.990	1.010		0.999	0.999				
N	0.510	0.515		0.512	0.512				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		0.313	0.313				
S	0.315	0.322		.316	0.316				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		0.797	0.797				
W	0.540	0.560		0.554	0.553				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.257	0.257				
Z	0.912	0.932		0.922	0.922				
AA	0.490	0.510		0.499	0.500				
AB	0.178	0.198		0.188	0.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>MA</u>
Date: <u>11/11/16</u>

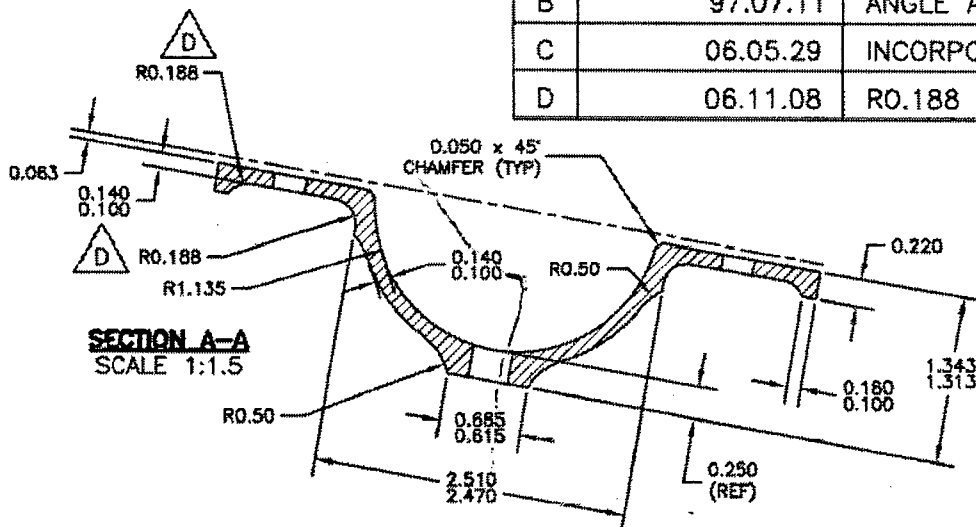
Audited by: <u>[Signature]</u>
Date: <u>11.11.17</u>

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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	





DESIGN #1	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

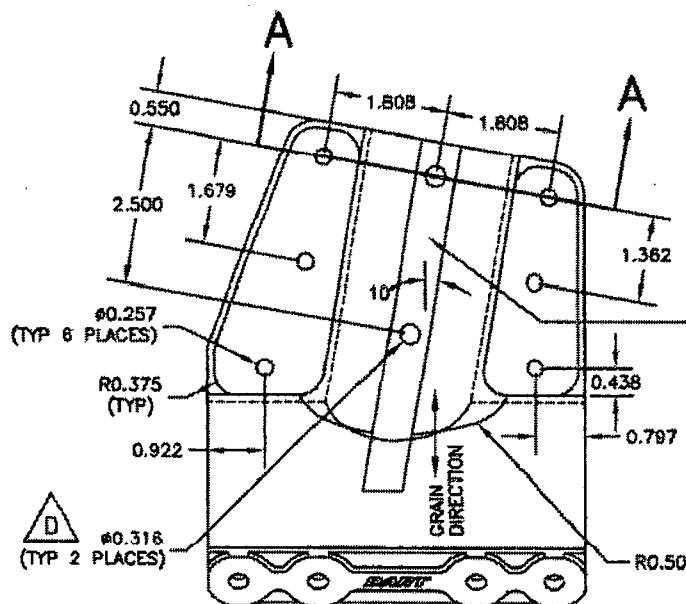


RELEASED

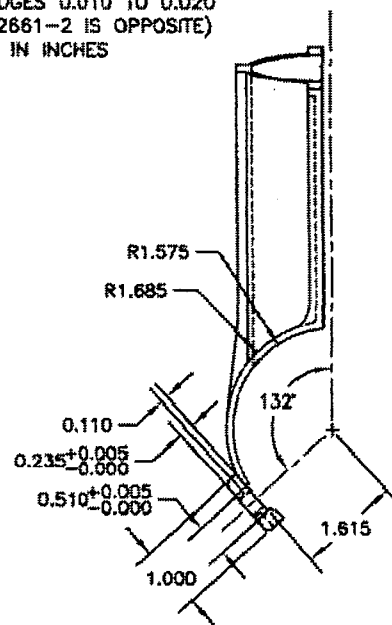
07.02.12 [Signature]

## NOTES:

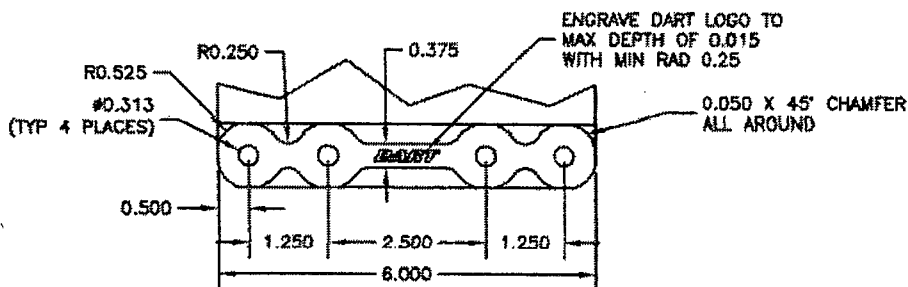
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



D2661-1 SADDLE OUTSIDE



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